

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021960**Date Inspected:** 23-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector randomly observed the following work in progress in the Bay 14:

SMAW welding of weld joint DP3172-001-018 located on PCMK OBG 14W. Welder was identified as 037780. QC was identified as ZPMC An Qing Xiang (QC1). Weld variables recorded by QC1 appeared to comply with WPS-B-T-2212-TC-U4b-FCM-1 as verbally identified by QC1.

SMAW welding of weld joint DP3172-001-019 located on PCMK OBG 14W. Welder was identified as 066038. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2212-TC-U4b-FCM-1 as verbally identified by QC1.

SMAW welding of weld joint DP3172-001-020 located on PCMK OBG 14W. Welder was identified as 066480. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-T-2212-TC-U4b-FCM-1 as verbally identified by QC1.

SMAW tack welding during fit-up of weld joint SEG3020Y-027 located on PCMK OBG 14W. Welder was identified as 045246. QC was identified as ZPMC CWI Sun Tian Liang (QC2). Weld variables recorded by QC2 appeared to comply with WPS-B-P-2213-FCM-1 as verbally identified by QC2.

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## WELDING INSPECTION REPORT

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FCAW welding of weld joint SEG3020BB-113 located on PCMK OBG 14W. Welder was identified as 067949. QC was identified as ABF CWI Li Shi You (QC3). Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Li Ping (QCA3), who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA3. See photo below showing the welding operation in process.

SMAW welding of weld joint SEG3020R-024 located on PCMK OBG 14W. Welder was identified as 067764. QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA3. See photo below showing the welding operation in process.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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